

# Work Order ID 61134

Monday, August 09, 2010 11:54:39 AM

SHIP TODAY

Page 1

Item ID: D4014-1

Revision ID:

Item Name: Switch Plate

Start Date: 8/9/2010 Start Qty: 1.00

Required Date: 8/9/2010 Req'd Qty: 1.00

Reference:

Accept

Cust Item ID:

Customer:

Setup

Start

Stop

Run

Start

Stop

Approvals:

Process Plan: *mt*

Date: 10-8-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4014

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

0.00

10-8-9

2

*ES 10/08/09 (2)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

10-8-9

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Item ID: D4014-1

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Start Date: 8/9/2010 Start Qty: 1.00

Required Date: 8/9/2010 Req'd Qty: 1.00

Reference:

Accept



Setup Start  
Stop



Cust Item ID:  
Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

8/10/08/09

(42)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

⇒ 10/08/09

X2

Ø

151



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

1112588

Memo

Start Time: 2:30pm  
Oven Temperature: 320°C  
Finish Time: 3:00pm

0.00

0.00

⇒ 10/08/09

X2

Ø

# Work Order ID 61134

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Item ID: D4014-1

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Start Date: 8/9/2010 Start Qty: 1.00

Required Date: 8/9/2010 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

JS 0/08/09 (2)

170



Packaging

Packaging

Identify as per dwg & Stock Location: GA

0.00

Memo

0.00

JS 0/08/09 (2)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/08/09  
mf  
10-8-9

# Picklist Print

August 9, 2010 12:44:52 PM

Page 1

Work Order ID: 61134

Parent Item: D4014-1

Parent Item Name: Switch Plate



Start Date: 8/09/10

Start Qty: 1.00

Required Date: 8/09/10

Required Qty: 1.00

Comments: IPP rev A 09.12.18 new Issue Prelim EC verified: DD IPP Rev:B  
10.05.17 as per ECN10-562 DD verf:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No				sf	58.1200	0.007	0.007			



6061-T6 Sheet 0.032"



18 10-8-9

Location

MAT21

Loc Qty

58.12

110063

3

112763

41.12

16954

8

18375

6

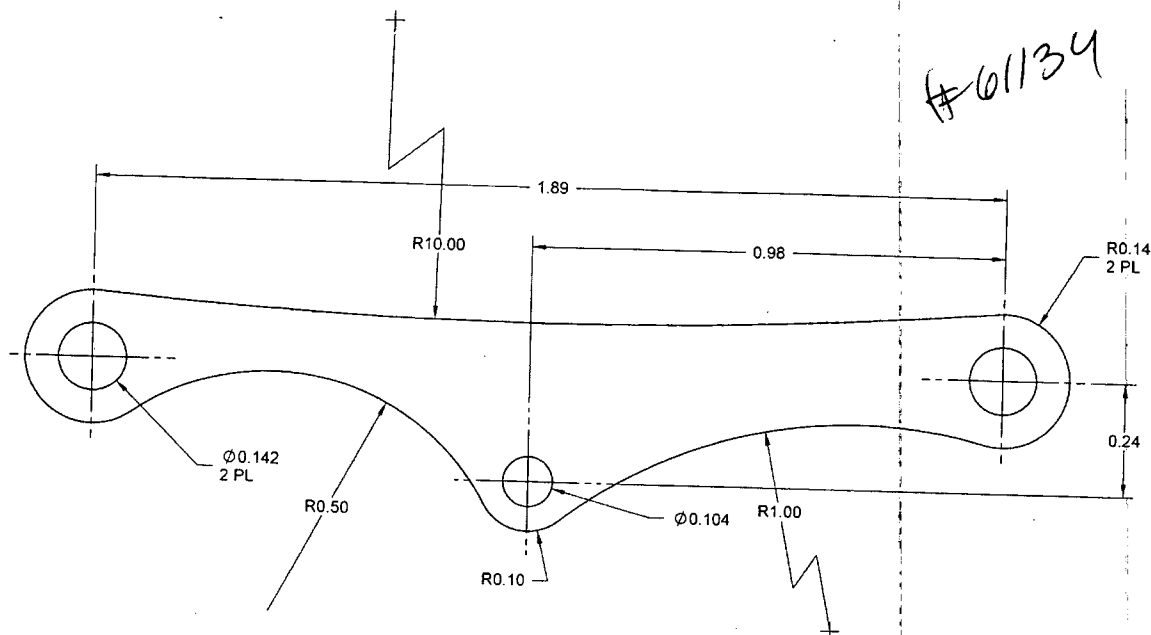
Loc Code

18375

(2)



DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4014-1	JCA-M47-2-30



**D4014-1 SWITCH PLATE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.025 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.025
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		10.03.11
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.11		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4014** REV. A  
TITLE: **COVER** SCALE: NTS  
SHEET 1 OF 2

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2010-05-05  
MD